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NOTES:

1. THIS IS A UHV ASSEMBLY. KEEP THE UHV PARTS CLEAN DURING ASSEMBLY AND WRAP UP FOR PACKING WITH ALUMINUM FOIL.
2. DEVICE SHALL BE LEAK TESTED USING A MASS SPECTROMETER WITH MINIMUM SENSITIVITY FOR HELIUM OF 2 x 10⁻¹⁰ STANDARD CC/SEC PER LEAK METER DIVISION, SUCH AS:
ALCATEL ASM-110TCL
VARIAN NCR 925 OR 936
VEECO MS-9, MS-90 OR MS-18
DuPONT CEC 24-120B
CALIBRATION OF THE LEAK DETECTOR SENSITIVITY SHALL BE PERFORMED JUST PRIOR TO TESTING.
FINAL TEST WILL CONSIST OF SURROUNDING THE CHAMBER (BAGGING) WITH HELIUM. THE CHAMBER WILL BE REJECTED IF A 2% DEFLECTION IN THE MOST SENSITIVE RANGE OF THE LEAK DETECTOR IS SENSED WITHIN 1 MIN.
3. BEFORE ASSEMBLY OF SWAGelok MALE CONNECTORS, USE SILVER COOP THREAD LUBRICANT (FROM SWAGelok CO.) TO ALLOW CONNECTION TO BE DISASSEMBLED WITHOUT SPECIAL TOOLS.
4. ALL DIMENSIONS WITH [] ARE MILLIMETERS AND FOR REF. ONLY
5. WATER PRESSURE TEST AT 500 PSI AFTER ASSEMBLING.

INSTRUCTIONS FOR INSTALLATION OF TUBING

1. INSTALL THE TUBE INTO THE FITTING UNTIL IT IS BOTTOMED AGAINST THE SHOULDER OF THE BODY.
2. TIGHTEN NUT TO APPR. 1/8 TURN PAST FINGER TIGHT.
3. SCRIBE A LINE ON NUT AT 6 O'CLOCK.
4. HOLDING THE FITTING WITH A WRENCH, TIGHTEN NUT PAST ONE COMPLETE TURN AND STOP TURNING WHEN SCRIBE MARK IS AT 9 O'CLOCK. (1-1/4 TURN)
5. SUFFICIENT PULL-UP IS REACHED WHEN SWAGelok GAP INSPECTION GAGE (MS-IG-468) DOES NOT FIT INTO GAP BETWEEN NUT AND BODY.

SOURCE

(SWAGelok)
DEARBORN VALVE & FITTING CO.
1540 N. OLD RAND ROAD
P.O. BOX 847
WAUCONDA, IL. 60084-0847
708-526-6900
FAX: 708-526-1221

3	SS-600-1-4	CONNECTOR MALE TUBE FITTING	SST	4
2	P4105090803-200100	6" O.D. BEAMLINE WINDOW WELDMENT ASSEMBLY		1
1	P4102010109-200001	4" I.D. BE WINDOW TUBING	SST	2
ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
PARTS LIST				
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES FRACTIONS DECIMALS X XX - .XX (XX) XX - .XX (XX) SURFACE ROUGHNESS 125 REMOVE ALL BURRS AND BREAK SHARP EDGES (R&M) SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST AMS 491 DIMENSIONS & TOLERANCES IN ACCORDANCE WITH LATEST Y14.5				
LOG NUMBER A19157		THIS DRAWING IS THE PROPERTY OF ARGONNNE NATIONAL LABORATORY		
DRAWN BY FUHRMANN		DATE 6/15/94	DESIGNED BY D. SHU	DATE 10/13/94
CHECKED BY J. WOTHE		DATE 10/12/94	PROJECT MGR. M. KUZAY	DATE 10/13/94
DESIGNER D. SHU/FUHRMANN		APPROVED/RELEASED		
RESPONSIBLE ENGINEER D. SHU		DATE 10/13/94		
MATERIAL SEE PARTS LIST		SCALE 1:1	SHEET 1 of 1	DWG NUMBER P4105090803-200000-00